

Work Order ID 55392

January 15, 2010 9:51:28 AM



Page 1

Item ID: D3230-041

Accept



Setup Start



Revision ID:

Item Name: Basket Wedge Assembly

Stop



Start Date: 1/15/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/22/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3230

Rev C

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut 3/4 x 3/4 square tubing as per Dwg D3230 SH
2- Drill and c/sink holes SH
3- cut mesh as per dwg
4 -Deburr & Remove all Markings From Material SH
5-Weld bushings and fabricate basket wedge assembly as per D3230 SH
A/R SS ROD Batch: 4109213

SH 10/01/20

(1x)

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 10.01.21

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Work Order ID 55392


January 15, 2010 9:51:28 AM


Page 2

Item ID: D3230-041 Accept  Setup Start 
Revision ID:
Item Name: Basket Wedge Assembly Stop 

Start Date: 1/15/10 Start Qty: 1.00  Cust Item ID:
Required Date: 1/22/10 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	=> 5.06/21			(XL)			

140  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 1113170 Memo: 1ST COAT: START TIME: 8:30AM OVEN TEMPERATURE: 400°F FINISH TIME: 9:00AM **** if necessary**** 2ND COAT: START TIME: 9:00AM OVEN TEMPERATURE: 400°F FINISH TIME: 9:30AM	0.00 0.00	=> M 10-01-28			(X1)	✓		
---	---	--------------	---------------	--	--	------	---	--	--

Work Order ID 55392

January 15, 2010 9:51:29 AM

Page 3

Item ID: D3230-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Basket Wedge Assembly

Start Date: 1/15/10

Start Qty: 1.00

Cust Item ID:

Required Date: 1/22/10

Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

BR 10-01-28

②

✓



QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location: _____

0.00

Packaging



Packaging

Memo

PDP85 389

0.00

Per 1/28

10-1-28 (10) ✓

Packaging

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/29 MF
10-1-28

Picklist Print

January 15, 2010 9:51:26 AM

Page 1

Work Order ID: 55392

Parent Item: D3230-041

Parent Item Name: Basket Wedge Assembly


Comments: IPP Rev:D 09-02-25 rev.c as per dwg DD verified by:EC

Start Date: 1/15/10

Required Date: 1/22/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-3  Basket Hinge		Manufactured	No			110	Each	37.0000	2.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

30

50024

2

54863

28

Main Warehouse

WA

7

53831

7

D2327-3

Manufactured No

110

Each

29.0000

2.0000



Spacer Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

29

44274

4

44365

9

54135

16

2x

10/01/19

2x

10/01/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 15, 2010 9:51:26 AM

Work Order ID: 55392

Parent Item: D3230-041

Parent Item Name: Basket Wedge Assembly


Comments: IPP Rev:D 09-02-25 rev.c as per dwg DD verified by:EC

Start Date: 1/15/10

Required Date: 1/22/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3759-1  Bushing		Manufactured	No			110	Each	71.0000	5.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA 71

53442 2

54072 29

55093 40

M304EX0.75-16F

Purchased

No

110

sf

1,189.675

5.4211



Expanded Metal Flat SS

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT 1189.675006

110134 3.4

111956 0.000017

112147 9.4736E-06

112949 43.42358

113205 0.0093

113497 292.8421

113555 850

5x SY 10/01/19

5.4211 SY 10/01/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 3

January 15, 2010 9:51:26 AM

Work Order ID: 55392



Parent Item: D3230-041



Parent Item Name: Basket Wedge Assembly

Start Date: 1/15/10

Required Date: 1/22/10

Comments: IPP Rev:D 09-02-25 rev.c as per dwg DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			110	f	185.0113	26.6280			
304 SQ Tube .75x.75x.065W												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	185.0112742	
113082	0.00419	
113245	185.007084	
Main Warehouse		
WA	0.0000047	
112398	0.0000047	

26.6280 *BY 10/01/19*
 1' feet
 END BAR
 SCRAP

January 15, 2010 9:51:26 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3230-041	BASKET WEDGE ASSEMBLY
3	1	D2221-1	RIB
4	2	D2232-3	BASKET HINGE
5	2	D2327-3	SPACER BUSHING
6	1	D3230-1	RIB
7	1	D3230-2	RIB
8	1	D3230-3	RIB
9	1	D3230-4	RIB
10	4	D3230-5	RIB
11	1	D3230-7	RIB
12	2	D3230-9	SIDE MESH
13	1	D3230-11	FRONT MESH
14	5	D3759-1	BUSHING

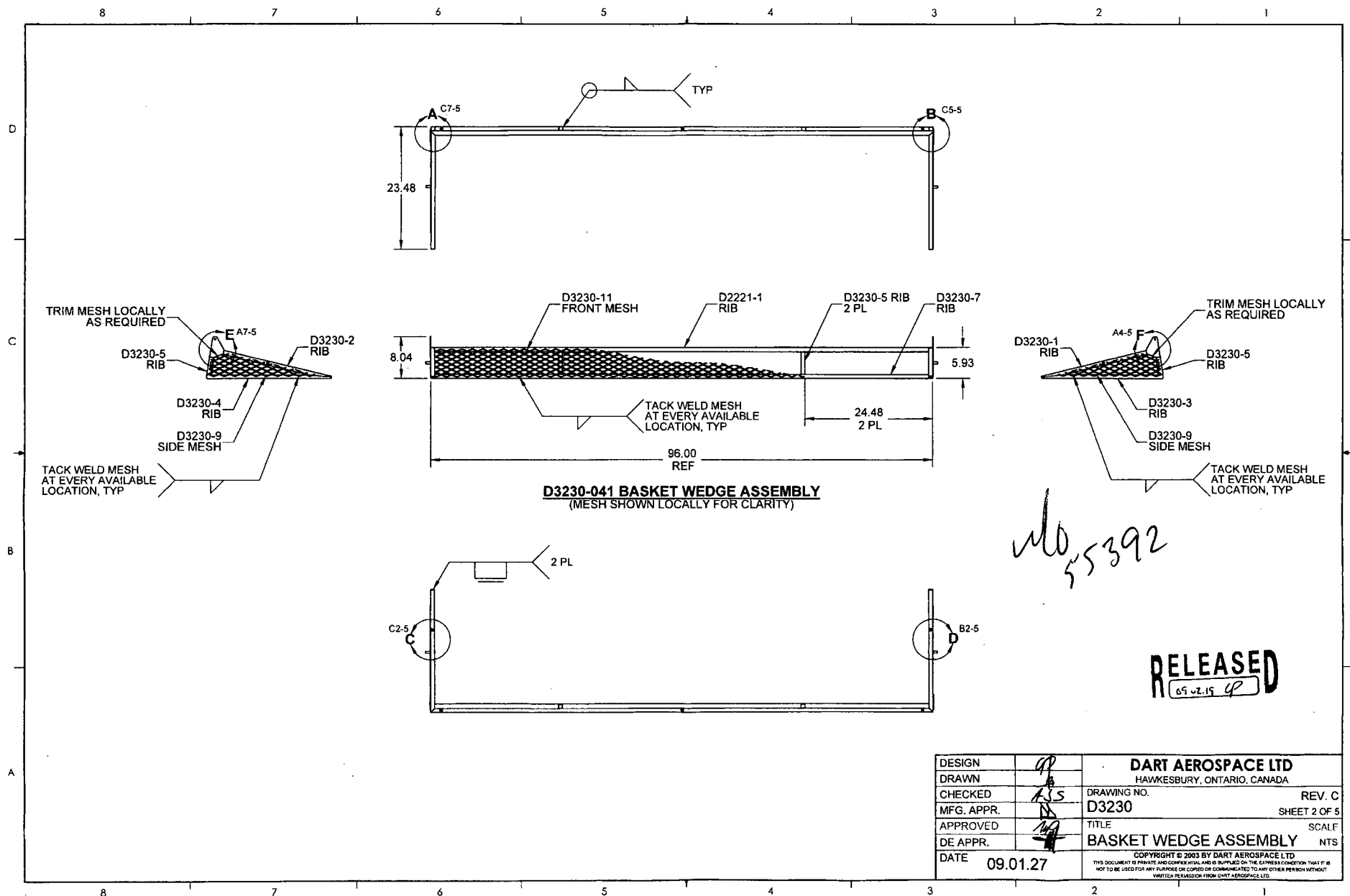
D3230-041 BASKET WEDGE ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

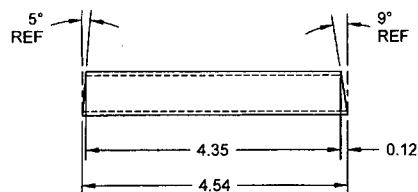
RELEASED
09.02.19 4P
PER ECN 49-534

C	REDESIGN (SEE NCR 09-010); REFORMAT DRAWING TO CURRENT STANDARDS	MB	09.01.27
B	15.75 WAS 16.00; REMOVE D2581; ADD VIEW B-B; D2327-3 ADDED	CB	06.11.10
A	NEW ISSUE	CP	03.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	DP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D3230	SHEET 1 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BASKET WEDGE ASSEMBLY	NTS
DATE	09.01.27	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

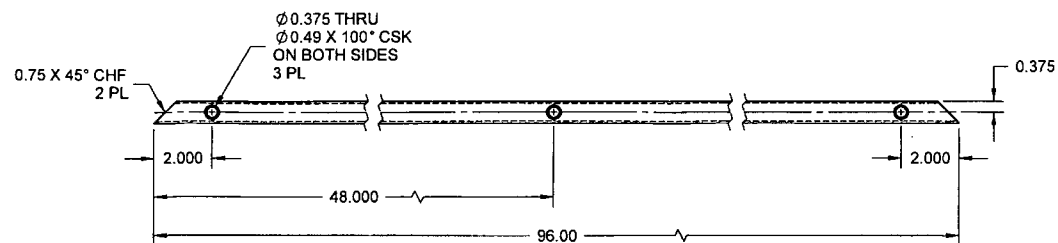
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3230-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 19.8 lbs
- 8) WELDING: PER DART QSI 004

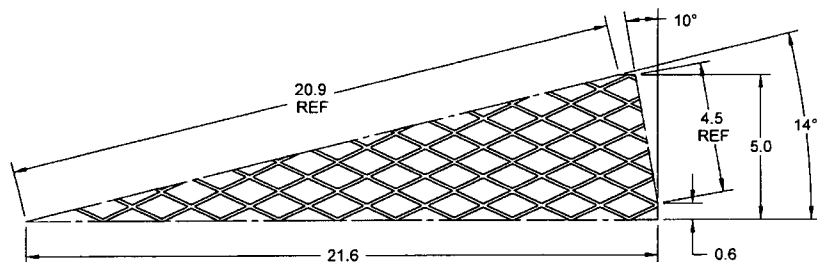




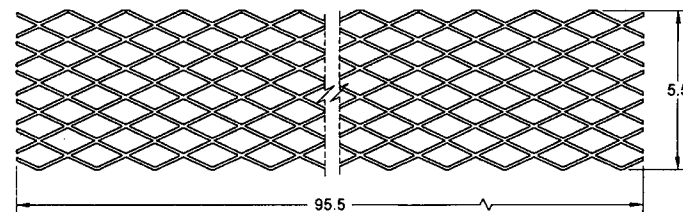
D3230-5 RIB



D3230-7 RIB



D3230-9 SIDE MESH



D3230-11 FRONT MESH

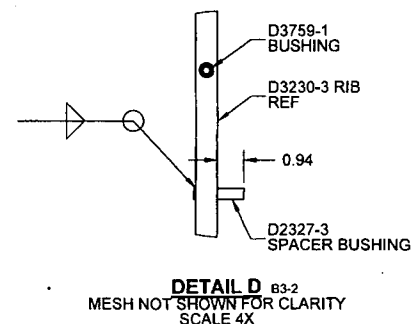
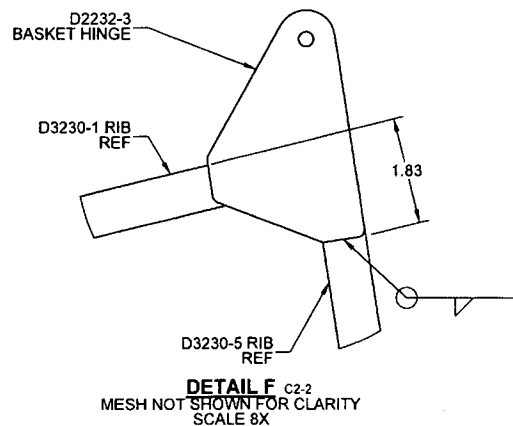
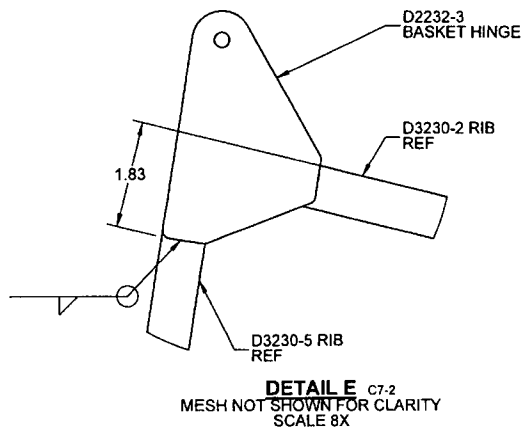
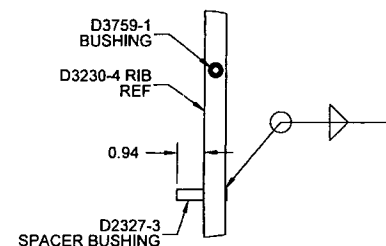
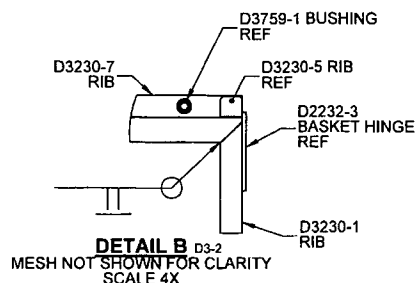
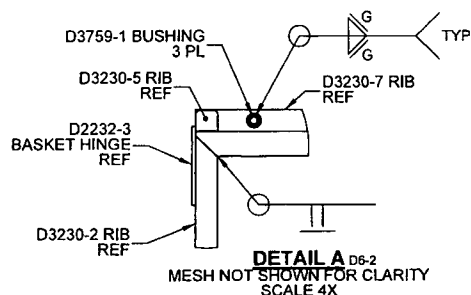
WLO 55392

RELEASED
09.02.19 4P

NOTES:

- 1) MATERIAL:
D3230-5/-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
D3230-9/-11: 3/4-16F EXPANDED STAINLESS STEEL
REF. DART SPEC. M304EX0.75-16F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3230-5 = 0.21 lbs; D3230-7 = 4.55 lbs
D3230-9 = 0.20 lbs; D3230-11 = lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED	JS		DRAWING NO. D3230	REV. C
MFG. APPR.				SHEET 4 OF 5
APPROVED			TITLE	SCALE
DE APPR.			BASKET WEDGE ASSEMBLY	NTS
DATE	09.01.27	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		



RELEASED
69-218 4

DESIGN	98	DART AEROSPACE LTD	
DRAWN	1.5	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1.5	DRAWING NO.	REV. C
MFG. APPR.	1.5	D3230	SHEET 5 OF 5
APPROVED	1.5	TITLE	SCALE
DE APPR.	1.5	BASKET WEDGE ASSEMBLY	
DATE	09.01.27	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			